


Date: Thursday, 11/9/2006 4:39:11 PM
 User: Kim Johnston











Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STA 155 BRACKET
Job Number	: 29410		
Estimate Number	: 11040		
P.O. Number	: <i>NIA</i>	Part Number	: D28042
This Issue	: 11/9/2006	Drawing Number	: D2804 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>NIA</i>	Drawing Revision	: C
Previous Run	: 29182	Material	: <i>NIA</i>
Written By	: 	Due Date	: 11/24/2006
Checked & Approved By	: _____	Qty:	10 Um: Each
Comment	: Est. A00.11.06 New Issue EC Est. B06.05.30 Blanks on wtjetEC Est Rev:C As per Rev C 06-11-09 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X12000	6061-T6 Bar .50" x 12.0"
		
Comment: Qty.: 0.7875 f(s)/Unit Total : 7.8750 f(s) 6061-T6 Bar .50" x 12.0" Material: 6061-T6 bar 12.00" x 0.50" Batch: <i>M102508</i> <i>ml</i> <i>06 11 14</i> (10)		
2.0	WATER JET	FLOW WATER JET
		
Comment: FLOW WATER JET 1-Cut as per Template DT8534 Dwg Rev: <i>C</i> Prog Rev: <i>C</i> <i>ml</i> <i>06 11 14</i> (10) 2-Deburr if necessary		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio FA103 <i>J.F</i> <i>06/11/15</i> (10)		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>J.F.</i> <i>06/11/15</i> (10)		
5.0	QC8	SECOND CHECK
		
Comment: SECOND CHECK <i>SA</i> <i>06-11-15</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PA Date: 8/11/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 155 BRACKET

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Part Number: D28042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr

J.L 06/11/16

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ES 06/11/16

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Y/L FC 06/11/16 X 18

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST156

06/11/17 (10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/17 (15)

Job Completion



u 06-11-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/11/17	8.1	Qc3 inspect chemical conversion (permanent change)	EC FC	06/11/17			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: STA 155 Bracket		Part Number:	D2804-2
Inspection Dwg: D2804	Rev: EC 06.11.10	Page 1 of 1	

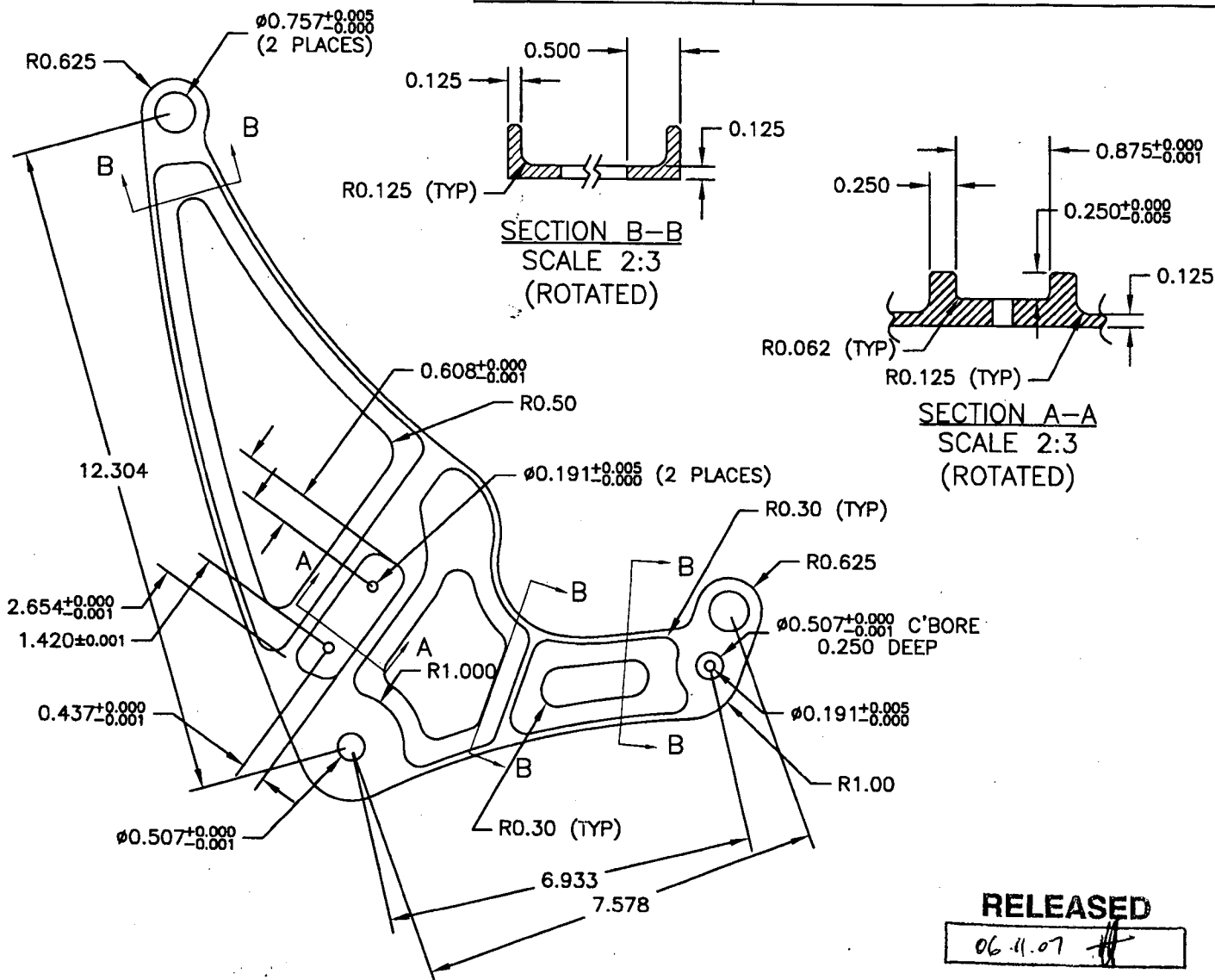
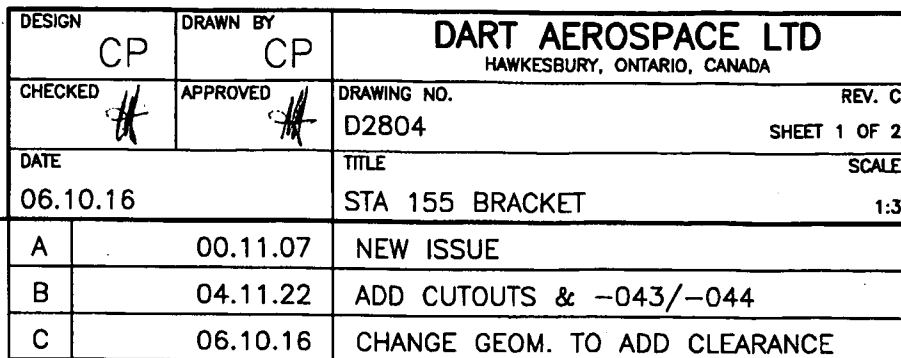
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	.135"	✓			
0.125	+/-0.010	.128"	✓			
R0.125	+/-0.010	R0.125"	✓			
0.250	+/-0.010	.251"	✓			
0.250	+0.000/-0.005	.249"	✓			
0.875	+0.000/-0.001	.874"	✓			
R0.062	+/-0.010	R.062"	✓			
Ø0.757	+0.005/-0.000	Ø.757"	✓			
R0.625	+/-0.010	.624"	✓			
12.304	+/-0.005	12.304"	✓			
Ø0.507	+0.000/-0.001	Ø.507"	✓			
0.437	+0.000/-0.001	.437"	✓			
0.608	+0.000/-0.001	.608"	✓			
Ø0.191	+0.005/-0.000	Ø.192"	✓			
1.420	+0.001/-0.001	1.421"	✓			
0.250 deep	+/-0.010	.248"	✓			
6.933	+/-0.005	6.935"	✓			
7.578	+/-0.005	7.579"	✓			
0.500	+/-0.010	.504"	✓			

Measured by: J.F.	Audited by: SA	Prototype Approval:	N/A
Date: 06/11/14	Date: 06.11.14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.12.10	New Issue	KJ/JLM	
B	05.04.25	Added 0.500 dimension	KJ/JLM	



- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

06.11.07

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HICK SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

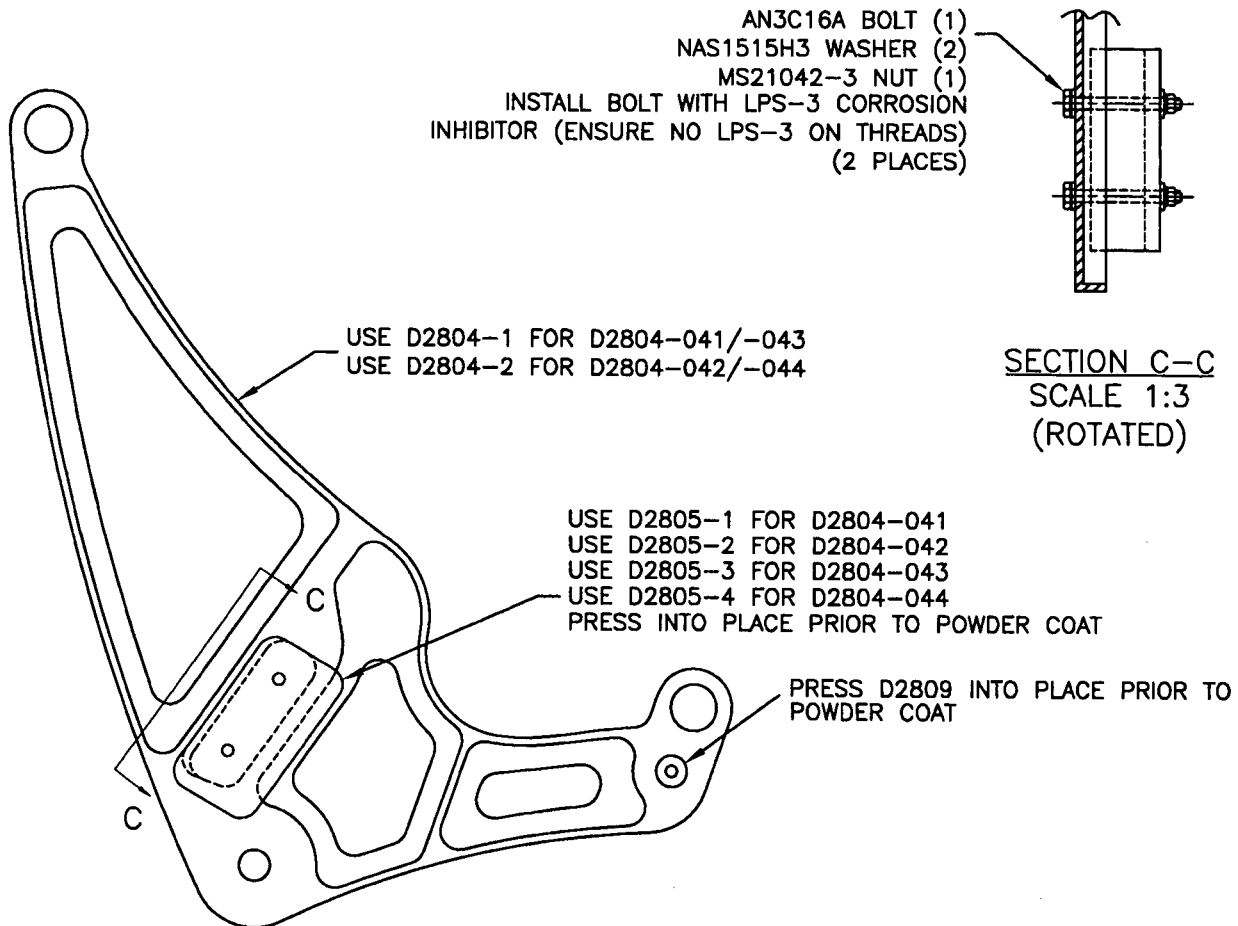
NO

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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



D2804-041/-043 BRACKET ASS'Y (SHOWN)
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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